

Date: Tuesday, 12/20/2005 9:44:33 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	206B BASKET LID
<b>Job Number</b> :	22087A		
<b>Estimate Number</b> :	11280		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D2330043
<b>This Issue</b> :	12/20/2005	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	UNDER REVIEW
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	N/A	<b>Drawing Revision</b> :	E
	<b>Type</b> :	<b>Material</b> :	N/A
	LARGE FAB ASSY	<b>Due Date</b> :	1/30/2006
<b>Written By</b> :	<u>SEE COMMENT BELOW</u>		<b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	<u>SEE ABOVE USER &amp; DATE</u>		
<b>Comment</b> :	Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K J		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 23.3625 f(s)/Unit Total : 23.3625 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: BH100560

PD

06-04-05

77.79

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Cut D2330-1-3-9 as per Dwg D2330

2-Drill hole in D2330-3 as per Dwg D2330

3-Deburr

PD

06-04-05

3.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D2232-1 HINGE

B23445

PD

06-04-05

4.0

D2329

Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2329 Label Plate

B23490

PD

06-04-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 9:44:34 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID

Job Number: 22087A

Part Number: D2330043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D23271	Spacer Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D2327-1	Bushing	B24873
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PD

06-04-05

6.0	D2581	Mounting Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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2	D2581	Mounting Chancel	B25824
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PD

06-04-05

7.0	M304EX07516F	Expanded Metal Flat Stai
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Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)

Pick:

Qty	Part Number	Description	Batch
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18 sf	M304EX0.75-16F	Expanded Metal	M100518
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PD

06-04-11

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner Jig

Deburr as required

A/R SS ROD Batch: M19555

PD

06-04-11

9.0	QC5/9	WELD INSPECTION
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Comment: WELD INSPECTION

06/04/11

10.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

DL

06/04/13 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 9 Date: 06/04/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 9:44:34 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID

Job Number: 22087A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 09 13

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

N/A

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06 10 20

Job Completion



LC 06 10 20

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

5/04

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>22087</b>
<b>Description:</b> 206B Basket Lid	<b>Part Number:</b>	<b>D2330-043</b>
<b>Drawing:</b> D2330 Rev. <sup>DI</sup> <del>D</del> Pages 1,2,4, & 5	<b>Qty:</b>	<b>1</b>

Step	Location	Procedure	By	Date	Qty																				
1	DC	Open Traveller <b>Dwg not required</b>	JS	04.12.14	1																				
2	WS	Cut 3/4" x 3/4" square tubing as per Dwg D2330 Material: 304/316 SS tube .060" wall Batch																							
3	WS	Drill hole in D2330-3 as per Dwg D2330																							
4	WS	Deburr																							
5	WS	Pick: <table><tr><td><u>Qty</u></td><td><u>Part Number</u></td><td><u>Description</u></td><td><u>Batch</u></td></tr><tr><td>1</td><td>D2329</td><td>Label plate</td><td>_____</td></tr><tr><td>1</td><td>D2327-3</td><td>Bushing</td><td>_____</td></tr><tr><td>2</td><td>D2581</td><td>Mounting Chanel</td><td>_____</td></tr><tr><td>18 sf</td><td>M304EX0.75-16F</td><td>Expanded Metal</td><td>_____</td></tr></table>	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	1	D2329	Label plate	_____	1	D2327-3	Bushing	_____	2	D2581	Mounting Chanel	_____	18 sf	M304EX0.75-16F	Expanded Metal	_____			
<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>																						
1	D2329	Label plate	_____																						
1	D2327-3	Bushing	_____																						
2	D2581	Mounting Chanel	_____																						
18 sf	M304EX0.75-16F	Expanded Metal	_____																						
6	WS	Weld as per Dwg D2330 using Welding Table and corner Jig Deburr as required																							
7	QC9 & 6	Inspect Welding and Dimensions																							
8	FP	Powder Coat White (Ref. 4.3.5.2) as per QSI 005 4.3																							
9	QC3	Inspect Powder Coat																							
10	FP	To GA Cell for Assembly																							

Rev	Date	Change	Revised By	Approved
B	94.12.03			JB
C	99.09.20	Re-format (was lpp-341B)	EC	
D	99.12.14	Re-format , removed step 14,15	EC	
E	00.06.26	Removed P/O for powder coat	EC	
F	02.07.23	Re-format, removed inspect level 5, added level 6	KJ	
G	02.09.04	M304EX0.75-16F was M750-16FXS-S/S	KJ <i>RF</i>	<i>RF</i>

RELEASED  
32/09/09 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_